

NOTES

1. INTERPRET DRAWING PER GLOBAL ENGINEERING DOCUMENTS DRAWING REQUIREMENTS MANUAL.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M.
3. DIMENSIONS ARE IN INCHES.
4. INTERPRET WELDING AND NONDESTRUCTIVE EXAMINATION SYMBOLS PER AWS A2.4.
5. USE PROCEDURES, WELDERS, WELDING OPERATORS AND TACKERS QUALIFIED PER AWS B2.1.
6. ASSEMBLE MALE NUT, FIND NO. 8, TO REDUCING ADAPTER, FIND NO. 7, BEFORE WELDING REDUCING ADAPTER TO SOCKET WELD GLAND, FIND NO. 6.

TOP VIEW
SCALE 0.125

SEE DETAIL X-

DETAIL X
SCALE 0.500

PICTORIAL VIEW
SCALE 0.125

6	2		SS-12-VCR-4	MALE NUT	STAINLESS STEEL	---	8	
6	2		SS-12-VCR-3	SOCKET WELD GLAND	STAINLESS STEEL	---	7	
6	2		SS-12-MTW-8-8TSW	REDUCING ADAPTER	STAINLESS STEEL	--	6	
	1		107030600M8E8700A168-I	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	5	
	1		107030600M8E8700A164-I	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	4	
	1		107030600M8E8700A163-I	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	3	
	1		107030600M8E8700A103-I	MULTI C V INSR PLUG W/ALIGNMENTS	---	---	2	
4	5		107030600M8E8700A102-I	UPPER MULTI C V INSR PLUG W/TUBING	---	---	1	
107030600M8E8700A000		-	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
			NEXT ASSEMBLY		PARTS LIST			

WEIGHT: APPROX. 2,351 LBS.

PRELIMINARY

QUALITY VERIFICATION		
MECHANICAL AND STRUCTURAL REFERENCE: SWS-QA-6002		
QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO
303	MATERIAL MILL TEST REPORT	-
325	MATERIAL SELLER CERT	-
326	SPECIAL MATERIAL INSPECTION REPORT	-
205	MANUFACTURING INSPECTION TEST PLAN	-
312	FIELD INSPECTION AND TEST PLAN	-
321	WELD AND BRAZE INSPECTION REPORT	-
322	HEAT TREAT REPORT (MCHART)	-
310	LEAK TEST REPORT	-
315	CLEANING CERT	-
318	DEVIATION REQUEST	-
319	NONCONFORMANCE PROCESS	-
323	DIMENSIONAL REPORT	-
330	FUNCTIONAL TEST REPORT	-
:	:	:
:	:	:
:	:	:
:	:	:
:	:	:
100	DOCUMENTATION	-

* SYMBOL X INDICATES APPLICABLE TO ALL PARTS OR ITEMS

RPE	
REV. XX	DATE XX/XX/XX

DES	DWM/MEP	11/01	DATE		Oak Ridge National Laboratory	
ORW	M.E. PHILLIPS	11/01	operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC-05-84OR21400		Oak Ridge, Tennessee	
CHK			SIS		Spallation Neutron Source	
L2			SPALLATION NEUTRON SOURCE PROJECT MULTI CORE VESSEL INSERT UPPER MULTI C V INSR PLUG W/TUBING			
PI	T.E. FORNEK	11/01				
IS						
X						
IS						
				R/LUG	N	SHT OF CLASS
				8700	1ST	2
DRAWING APPROVALS			DATE	107030600M8E8700A102		
				REV		

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THIS DRAWING PRODUCED
ON PRO-ENGINEER

THIS DOCUMENT CONTROLLED BY
CHANGE CONTROL SYSTEM..._3
ENGINEERING PROCEDURES-TS-000

[illegible]

H

G

F

E

D

C

B

A

PARTIAL TOP VIEW
SCALE 1.000

PRELIMINARY

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P THIS DRAWING PRODUCED
ON PRO-ENGINEER

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6

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4

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2

SCALE AS NOTED TOLERANCES UNLESS OTHERWISE SPECIFIED FRACTIONS ± .01 XX DECIMALS ± .01 XXX DECIMALS ± .005 ANGLES ± 0°15' BREAK SHARP EDGES .06 MAX FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	 Oak Ridge National Laboratory operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22720 Oak Ridge, Tennessee 37831-6001	
	 Spallation Neutron Source	
SPALLATION NEUTRON SOURCE PROJECT MULTI CORE VESSEL INSERT SOLID PLUG		
	BLDG	FL SHT OF CLASS
	8700	1 2 2 U
107030600M8E8700A102		REV 00A

107030600M8E8700A102